

Work Order ID 64746

Wednesday, December 15, 2010 12:57:10 P

Page 1

Item ID: D3290-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Window Assembly

Start Date: 12/15/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 12/15/10 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	DEO Rev C1								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 (use prog. for D3290-1)

Dwg Rev: C1

Prog Rev: 4

2-Deburr if necessary

B10-12-16

(S)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-12-16

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/12/12/16

(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial, all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5. 10-12-16

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:10
OVEN TEMPERATURE: 320°
FINISH TIME: 2:40

5 10-12-16

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> all 10/12/12 5 0

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Cust Item ID:

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Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Small Fab	Small Fab	0.00				(5)			
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap								
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				(X)			
180  Packaging	Identify as per dwg & Stock Location: <u>290</u>	0.00							
Packaging	Memo	0.00							

SAD 10-12-22

8 10/12/23

11/14/23 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/23

PL 1012-23
5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, December 15, 2010 12:57:59 PM

Page 1

Work Order ID: 64746

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 12/15/2010


Required Date: 12/20/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B05.05.25 Added Step 11 KJ/JLM
IPP C06.05.09 Ecn 798 EC
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------


M6061T6S.063		Purchased	No			100	sf	169.1340	3.75	19.73684			
													
6061-T6 .063 Sheet													

Location	Loc Qty	Loc Code
MAT	131	
116308	131	
MAT21	38.134	
113608	38.134	

12-10-12-16

5

116308


D2126		Manufactured	No			160	f	76.1819	6.5	32.5			
													
Seal													

Location	Loc Qty	Loc Code
ST405	76.18192105	
48285	22.0884211	
57106	54.0935	

SAD 10-12-22

32.5

(D2126-0780) cut qty (1) at 78.00" as per dwg
per kit

D3290-3		Manufactured	No			160	Each	7.0000	1	5			
													
Window													

Location	Loc Qty	Loc Code
ST221	7	
57837	2	
58726	5	

SAD 10-12-22

5

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64746
Description: Window Frame		Part Number: D3290-1
Inspection Dwg: D3290	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	X		T B01	
14.00	+/-0.030	14.00	X		T	
Ø0.171	+0.005/-0.001	.171	X		V B02	
1.50	+/-0.030	1.510	X		V	
1.11	+/-0.030	1.110	X		V	
10.10	+/-0.030	10.10	X		T	
18.50	+/-0.030	18.50	X		T	
0.063	+/-0.010	.063	X		V	
R3.00	+/-0.030	3.00	X		R.G.	
R4.50	+/-0.030	4.50	X		R.G.	
Ø0.257	+0.006/-0.001	.258	X		V	
13.61	+/-0.030	13.61	X		T	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-12-16	Date: 10/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	
D	09.11.04	Dimension 0.063 was 0.040	KJ	

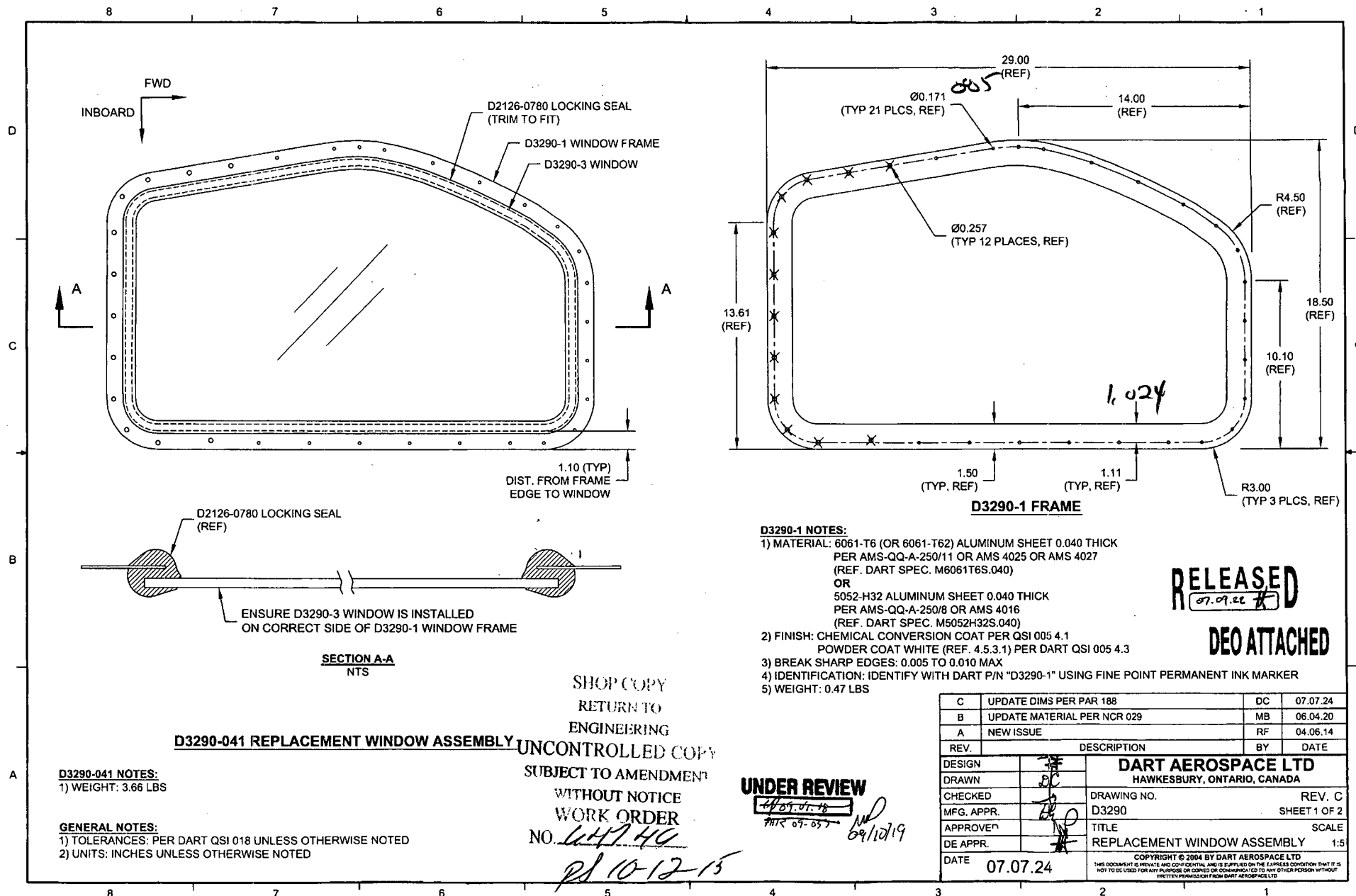
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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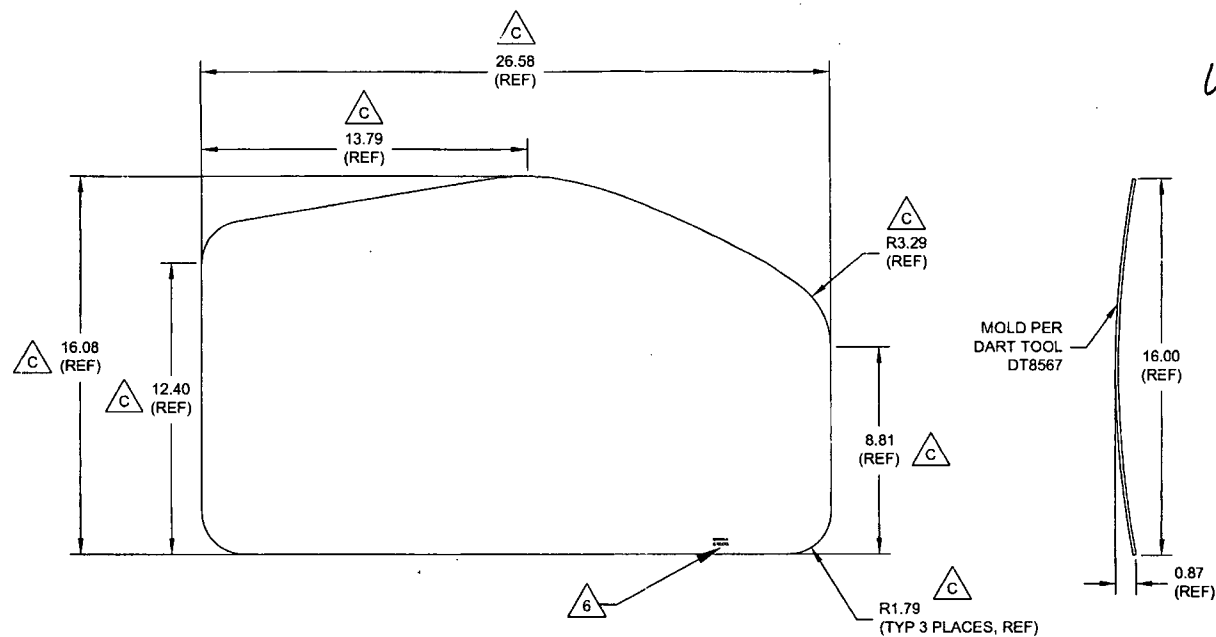
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D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

W. J. 10/10/19
UNDER REVIEW
10/10/19
DEO ATTACHED
RELEASED
07.09.22

DESIGN	<i>32</i>	DART AEROSPACE LTD	
DRAWN	<i>21</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>21</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>21</i>	D3290	SHEET 2 OF 2
APPROVED	<i>21</i>	TITLE	SCALE
DE APPR.	<i>21</i>	REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>GP</i>	CHECKED <i>JS</i>	MFG. APPR. <i>EZ</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

WLO 64744

RELEASED
 2009 -10- 09
WMP

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